Work Orde Tuesday, April 26						·				· · · · · · · · · · · · · · · · · · ·		Page 1
Revision ID:	D3290-041	Window Assembly		Accept					Setup	Start Stop		
Start Date: 4 Required Date: 4 Reference:	4/26/2011 4/29/2011	Start Qty: 8.00 Req'd Qty: 8.00			Cust Item Customer:							
• •	Process Pla	an:	Date: <u>  -54-34</u> Date:	Tooling: SPC (Y/N):		oate:			Run	Start Stop		
Sequence ID/ Work Center ID	,	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr			<del></del>							
D3290	DEC	O Rev C1										
100 		FLOW WATER JET  Memo		0.00				13	11-5-	7_		
FLOW CNC Waterjet	t			: D3290-1)							(8)	
		QC2- Inspect parts off r	nachine FAI/FAIB	0.00				IR I	11-5-	~		
QC Quality Control		Мето		0.00						<u>,                                     </u>		

QC8- Inspect parts - second check

Quality Control

Memo

	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	C	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	Date: _			
	Res	solution:	Dispositio	n:	_ QA: N/C	Close	ed:	Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
5475 0755		Description of NC Corrective Action			tion B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
									·
						,			

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8x & Mf 11/05/09

QC

Page 2

Insp. Stamp

W/O:			W	ORK ORDER CHANG	SES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			tion B	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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	1	T. Control of the Con	1				1	1

#### Work Order ID 68962

Tuesday, April 26, 2011 1:46:33 PM



Page 3

Item ID:

D3290-041

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Window Assembly

**Start Date:** 

4/26/2011

Start Qty: 8.00

Req'd Oty: 8.00



Cust Item ID:

**Customer:** 

Tool ID

Reference:

		_		_		_	1.		
A	p	p	Г	o	V	а	15	:	

Process Plan:

Date:

Tooling:

Set Up/

Date:

Tool # Plan

Code

Start Run

Reject

Qty



Required Date: 4/29/2011

QC:

Date:\_\_\_\_\_

SPC (Y/N):

Date:

Stop

Reject

Number

Stop

Insp.

Stamp

Sequence ID/ Work Center ID

160

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

**Run Hours** 

0.00

0.00

170

QC

QC5- Inspect part completeness to step on W/O

Memo

Memo

000 Dillestic

Accept

Qty

Quality Control

180

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

W/O:	-		WC	ORK ORDER CHANG	SES			
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	;	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
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DATE	STEP	Description of NC			tion B	Verification		Approval
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Work	0	rder	ID	68962
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Tuesday, April 26, 2011 1:46:33 PM



Page 4

Item ID:

D3290-041

Accept



Setup Start



Stop

**Revision ID:** 

Item Name:

Replacement Window Assembly

**Start Date:** 

Required Date: 4/29/2011

4/26/2011

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Memo

Operation

Description

Date: Date:

Tooling: **SPC (Y/N):**  Date:

Date:

Tool # Plan

Code

Run

Accept

Qty

Start



Stop

Sequence ID/ Work Center ID

190 

QC

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Reject Reject Qty

Number

Insp. Stamp

Quality Control

0.00

N 15/18 4) N 11-05-18

	•									
W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORD	ER NON-CONFORM	MANCE	(NCR	)			
DATE	STEP	Description of NC			ection B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti		Chief Eng	QC Inspector
		•								

Work Order ID: 68962

Parent Item:

D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP B□05.05.25□Added Step 11□KJ/JLM□

IPP C□06.05.09□Ecn 798

 $EC\Box$ 

IPP Rev:D Now on Waterjet 06-06-16 JLM

IPP rev E rev C dwg

07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	372.0000	3.75	31.57895	5 B11-5-5		
				Location	1	Lo	<u>Qty</u>	Loc Code				(2)	
				MAT021			372		*******		_	( \( \( \) \)	
					116308		36		_		•		
					117285		336			17785	-		
D2126		Manufactured	No			160	f	78.2586	6.5	52			~ 1
Seal													1
				Location	Į.		e Oty	Loc Code					11/05/
				ST405	53106	7	8.2586				-		
				,	57106 64918	7	4 1.2586		_	52.	Ct		
(D2126-0780) cut qty (1) at	78.00" as per dwg			ć	3.7.3	,	1.2300		<del></del>		er.		
***per kit***						1.60	F .	0.000		_			
D3290-3	t IIII	Manufactured	No			160	Each	0.0000	1 	8 ~			
Window								Provin					M.
								P6/60 <sub>0</sub>	l i	× >		4,	165/19
								B67603 B69559	, p	×5 3			′, ′ >
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Page 1

W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			tion B	Verific		Approval	Approval
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-									
		7.555							
	1		1		I	1		1	

DART AEROSPACE LTD	Work Order:	68662
Description Mindow France	Dord Number	D2200 4
Description: Window Frame	Part Number:	D3290-1
Inspection Dwg: D3290 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29,00	+		T 1801	
14.00	+/-0.030	14.00	6		+	
Ø0.171	+0.005/-0.001	้เปร	9-		V ROZ	
1.50	+/-0.030	1,509	7		V	
· 1.11	+/-0.030	1.104	>		V	·-
10.10	+/-0.030	10.10	+		T	
18.50	+/-0.030	18,50	>		-	
0.063	+/-0.010	(30,	>		V	
R3.00	+/-0.030	300	2_		R.G.	
R4.50	+/-0.030	4.50			R.G.	1 1
Ø0.257	+0.006/-0.001	757	>		V	
13.61	+/-0.030	13.61	>		1	
						· · · · · · · · · · · · · · · · · · ·
	_					

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11 - 4-7	Date: 11 UT UT	Date:	N/A

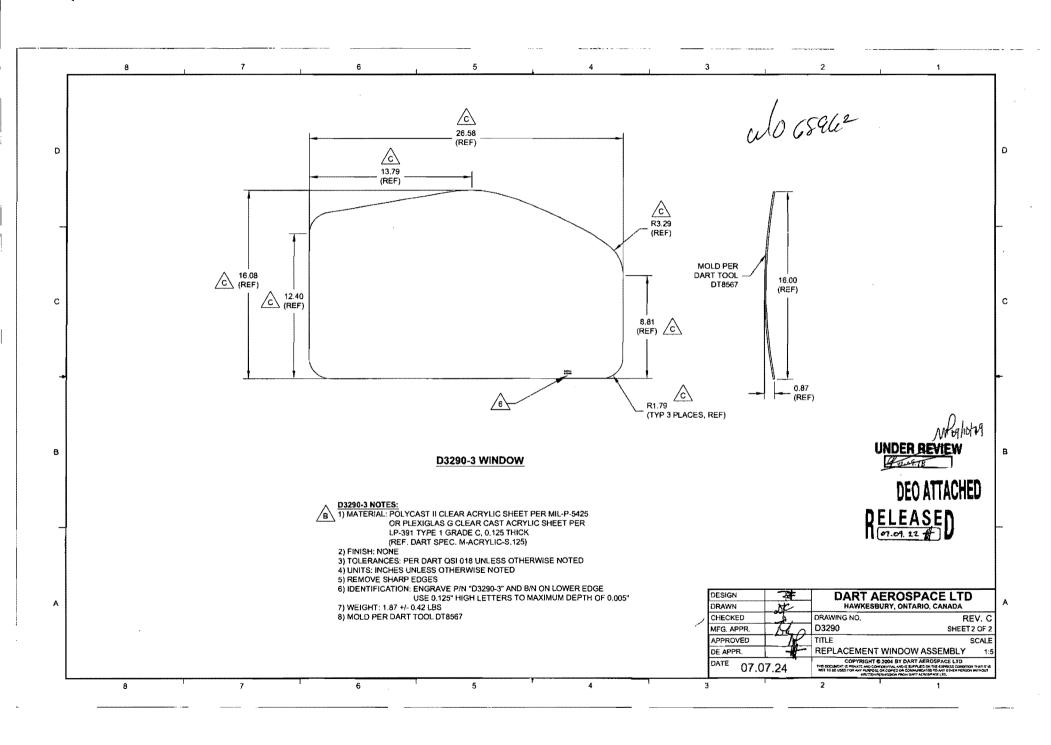
Rev	Date	Change	_	Revised by	Approved
Α	06.09.19	New Issue P/O D3290-041		KJ/JLM	
В	07.07.18	13.61 dimension removed		KJ/JLM	• • •
С	07.09.28	Dimensions update per Dwg Rev C		KJ/EC/DD <sub>A</sub>	4.1
D	09.11.04	Dimension 0.063 was 0.040		KJ KJ	1/1

DATE	STEP	DD/			<del></del>				
		PR(	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Ye	s No C	)QA:	Date: _	
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NCR:			WORK ORDE	ER NON-CONFORM	IANCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sig	Date Qty Chief Eng / Prod Mgr  S No DQA: Date: Closed: Date: CR)  Verification Approval Chief Eng	Approval QC Inspector		
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY 6 p/11-09-26 SUBJECT TO AMENDMENT WITHOUT NOTICE 29.00 WORK ORDER (REF) FWD Ø0.171 14.00 D2126-0780 LOCKING SEAL (TYP 21 PLCS, REF) INBOARD (REF) (TRIM TO FIT) O D D3290-1 WINDOW FRAME D3290-3 WINDOW R4.50 (REF) Ø0.257 (TYP 12 PLACES, REF) 18.50 13.61 (REF) (REF) 10.10 (REF) 0 .982 1.10 (TYP) 1.50 DIST, FROM FRAMÉ (TYP, REF) (TYP, REF) R3.00 EDGE TO WINDOW (TYP 3 PLCS, REF) **D3290-1 FRAME** D2126-0780 LOCKING SEAL D3290-1 NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 . в (REF. DART SPEC, M6061T6S,040) 5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 **ENSURE D3290-3 WINDOW IS INSTALLED** (REF, DART SPEC, M5052H32S,040) ON CORRECT SIDE OF D3290-1 WINDOW FRAME 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3 SECTION A-A NTS 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER 5) WEIGHT: 0.47 LBS UPDATE DIMS PER PAR 188 07.07.24 DC UPDATE MATERIAL PER NCR 029 В MB 06.04.20 NEW ISSUE 04.06.14 Α RF **D3290-041 REPLACEMENT WINDOW ASSEMBLY** REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA D3290-041 NOTES: DRAWN 1) WEIGHT: 3.66 LBS CHECKED DRAWING NO. REV. C MFG. APPR. D3290 SHEET 1 OF 2 APPROVED SCALE 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DE APPR. REPLACEMENT WINDOW ASSEMBLY 2) UNITS: INCHES UNLESS OTHERWISE NOTED COPYRIGHT © 2004 BY DARY AEROSPACE LTD
IT IS PROVATE AND CONTRIBUTION AND IS SUPPLED ON THE LEFTELDS CONTRIBUTION AND IS SUPPLED ON THE LEFTELDS CONTRIBUTION OF THE PER COPIED OR COMMUNICATED TO ANY COTTEMP PER DATE 07.07.24

W/O:			W	ORK ORDER CHANG	ES				
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W/O:			V	ORK ORDER CHANG	<b>iES</b>					
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DRAWING I	NO. T	TITLE			REV, C	DART AE	ROSPACE LTD	D.E.O. NO.		SHEE	T NO.	SCALE
D3290	F	REPLACEME	ENT WIND	OW AS	SEMBLY	ENGINE	ERING ORDER	D3290-C-1	^	SHEET	1 OF 1	NTS
DRAWN	P		CHECKED	.[1	`	MFG. APPR.	E	APPROVED .	9	DE APPR.	-117	
DATE	09.09.1	8	DATE	04.09.1	8	DATE	69.09.18	DATE 09/09/	21.	DATE 0	9/09/	21

#### **PURPOSE:**

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

#### CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

w/v 68962

#### **D3290-1 NOTES**

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK (REPLACE)

PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027

(REF. DART-SPEC. M6061T6S.040) REF. DART SPEC. M6061T6S.063 (REPLACE)

OR

5052-H32 ALUMINUM SHEET 0.040 THICK (REPLACE)

PER AMS-QQ-A-250/8 OR AMS 4016

(REF. DART SPEC. M5052H32S.040) REF. DART SPEC. M5052H32S.063 (REPLACE)



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W/O:			WO	RK ORDER CHANGE	ES			22	
DATE	STEP	PRO	CEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQA</b>	:	Date: _	
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